



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D3319-3**Job Sheet 193979**

Part No: D3319-3

Job Qty: 42 pcs

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER
DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	12 pcs		5/3/19	0.00	2.80	Waterjet - Flow			22/19/05/13
110	QC 2	12 pcs		5/3/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			22/19/05/13
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			

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Container No: S180738



Part: D3319-3

Job No: 193979

Serial No/Batch: S180738

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 05/30/19

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120	QC 8	12 pcs	5/3/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	MAY 14 2019 40
					QC 8 - 52	9-89
					QC 8 - 23	
140	Small Fab - Brake NC - B4B	12 pcs	5/3/19	0.12 0.80	Small Fab - Brake - 1 - B4B	DAS 30 9-89
					Small Fab - Brake - 2 - B4B	MAY 23 2019
					Small Fab - Brake - 3 - B4B	
150	QC 5	12 pcs	5/3/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	MAY 23 2019 40
						9-89
160	Automated Welding - B4B	12 pcs	5/3/19	0.00 3.82	Automated Welding - 1 - B4B	
170	QC 10	12 pcs	5/3/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
180	QC 5	12 pcs	5/3/19	0.00 0.00	QC 10 - 9	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	

					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
190	Spray Paint - 2 - B4B	12 pcs	5/3/19	0.00 1.20	Spray Paint - 1 - B4B	RD 19-5-30
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200	QC 3	12 pcs	5/3/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	MAY 31 2019
					QC 3 - 19	
210	Packaging 3-1 - Stock - B4B	12 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
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					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70		
				QC 21 - SA - 53		

21 JUN 03 2019
0.00

Part Op **100** - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
140 - Form using DT8326 & DT8261 as per Dwg D3319
150 - (QC5- Inspect part completeness to step on W/O)
160 - 8259 Hardcoat Rod
170 - (QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O)
190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
 BATCH: 5166783
200 - (QC3- Inspect Part Finish)
210 - (Identify as per dwg & Stock Location: _____) Identify on inside surface using a permanent fine point marker with the following:
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	39 sf (3.25 ea)	100-Waterjet - Flow - 1	<u>5175009</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	39	374	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	.191	
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499	0.500	
3	Wearplate	0.316inches ± 0.010	0.326 0.306	0.317	
4	Wearplate	0.607inches ± 0.010	0.617 0.597	0.604	
5	Wearplate	2.940inches ± 0.030	2.970 2.910	2.942	
6	Wearplate	2.690inches ± 0.030	2.720 2.660	2.695	
7	Wearplate	3.527inches ± 0.010	3.537 3.517	3.530	
8	Wearplate	4.520inches ± 0.030	4.550 4.490	4.530	
9	Wearplate	5.063inches ± 0.010	5.073 5.053	5.068	
10	Wearplate	6.160inches ± 0.030	6.190 6.130	6.168	
11	Wearplate	0.600inches ± 0.030	0.630 0.570	0.615	
12	Wearplate	8.690inches ± 0.010	8.700 8.680	8.692	
13	Wearplate	30.790inches ± 0.010	30.800 30.780	30.790	
14	Wearplate	52.880inches ± 0.030	52.910 52.850	52.885	
15	Wearplate	62.770inches ± 0.010	62.780 62.760	62.775	
16	Wearplate	74.420inches ± 0.010	74.430 74.410	74.420	
17	Wearplate	75.520inches ± 0.030	75.550 75.490	75.520	
18	Wearplate	0.050inches ± 0.010	0.060 0.040	0.045	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

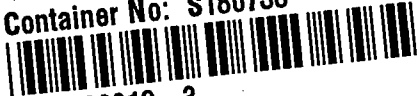
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐						
Date :	Sequence #:	QTY Affected :		MRB (QSI042)				
Description Work Order Deviation		Disposition			Completed By			
					Lead hand / Supervisor			
								QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
Other/Details:								



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